

Date: Monday, 25/05/2009 12:48:41 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 48191	
Estimate Number : 10940	
P.O. Number :	Part Number : D29381
This Issue : 25/05/2009 S.O. No. :	Drawing Number : D2938 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 47336	Material :
Written By :	Due Date : 12/06/2009 Qty: 8 Um: Each
Checked & Approved By : <u>JULIE DAWSON 09-05-25</u>	
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev: C As per Rev C 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Issue material from stock: 7075-T7351 (QQ-A-250/12)
 Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length
 (D6101-003) Batch No: 46410

out of Mat.

09/06/04 (5)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet
 5-Deburr

09/06/05 (5)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

09/06/08 (5)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

09/06/05 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 25/05/2009 12:48:42 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 48191

Part Number: D29381

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 09/06/08

(5)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 09/06/09

(5)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11:00AM

OVEN TEMPERATURE: 320°C

FINISH TIME: 11:30AM

MF 09-06-09

(5)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BP 09-06-9

(5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5742FA

FL 9/6/8

(5)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/10

Job Completion



MF 09-06-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 4891
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	By	Date
A	0.100	0.140		.117	.117	.116		
B	0.100	0.140		.120	.119	.119		
C	0.100	0.140		.125	.122	.123		
D	0.210	0.230		.280	.220	.220		
E	1.245	1.255		1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500		
H	0.510	0.515		.570	.570	.570		
I	1.572	1.582		1.577	1.579	1.578		
J	2.495	2.505		2.501	2.499	2.500		
K	0.257	0.262		.258	.258	.258		
L	0.312	0.317		.314	.314	.314		
M	0.235	0.240		.237	.238	.238		
N	0.100	0.140		.110	.110	.109		
O	0.540	0.560		.548	.547	.546		
P	0.490	0.510		.497	.497	.498		
Q	3.715	3.725		3.718	3.718	3.718		
R	2.720	2.760		3.740	3.744	3.743		
S	0.240	0.270		.251	.250	.250		
T	0.100	0.180		.136	.134	.135		
U	1.625	1.635		1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367		
W	0.316	0.321		.316	.317	.317		
X	1.250	1.270		1.262	1.265	1.264		
Y	1.565	1.585		1.577	1.579	1.579		
Z	0.178	0.198		.188	.188	.188		
AA								
AB								
AC								
AD								
AE								
AF								
AG								
AH								
Accept/Reject								

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 09/06/05	Date: 09/06/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 4891
Description: 206 Saddle, Outboard, Left side		Part Number: D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

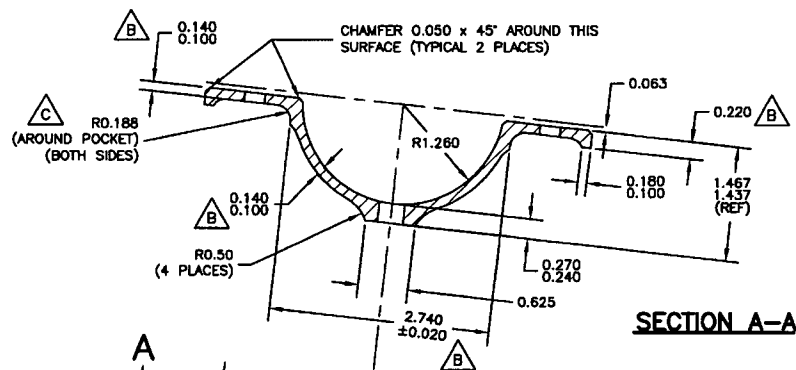
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	4	5				
A	0.100	0.140		.119	.120				
B	0.100	0.140		.121	.122				
C	0.100	0.140		.123	.125				
D	0.210	0.230		.220	.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.570	1.579				
J	2.495	2.505		2.499	2.499				
K	0.257	0.262		.256	.258				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.232	.240				
N	0.100	0.140		.109	.107				
O	0.540	0.560		.546	.547				
P	0.490	0.510		.497	.502				
Q	3.715	3.725		3.717	3.718				
R	2.720	2.760		2.745	2.743				
S	0.240	0.270		.250	.249				
T	0.100	0.180		.134	.135				
U	1.625	1.635		1.629	1.630				
V	1.362	1.372		1.365	1.369				
W	0.316	0.321		.317	.317				
X	1.250	1.270		1.263	1.264				
Y	1.565	1.585		1.578	1.578				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

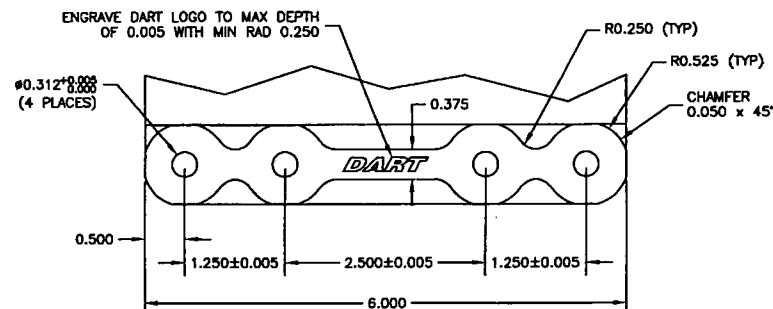
Measured by:	4/09/06/05
Date:	

Audited by:	09/06/08
Date:	

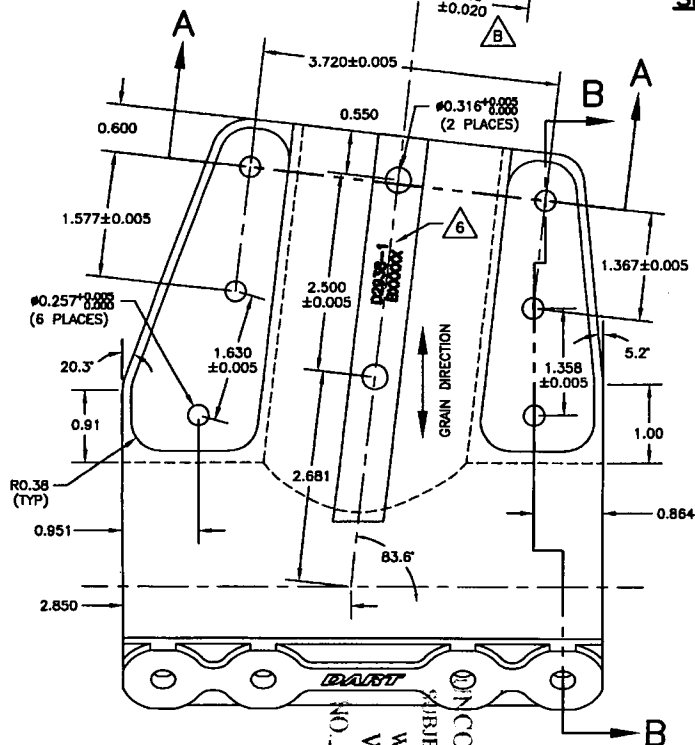
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



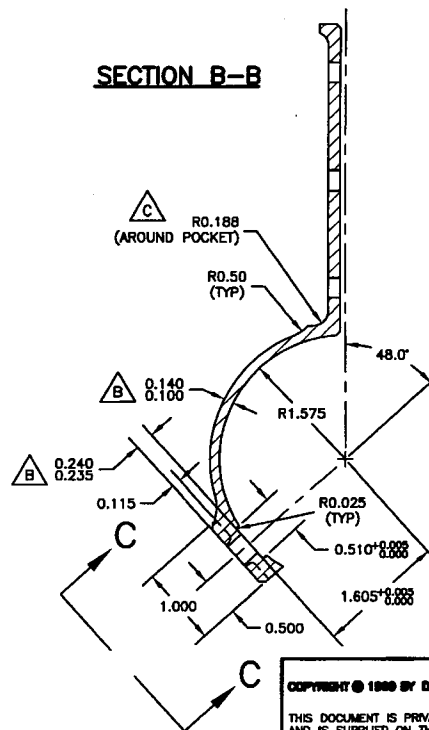
SECTION A-A



VIEW C-C



SECTION B-B



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE
		REV. C
		SHEET 1 OF 1
		SCALE
		2:3

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DART DART AEROSPACE USA, INC.
BELLINGHAM, WA

DRAWING NO. D2938

SADDLE OUTSIDE

07.02.12

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WORK ORDER